

Date: Friday, 2/23/2007 8:32:50 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY	
Job Number	: 30901				
Estimate Number	: 10713				
P.O. Number	: N/A		Part Number	: D3213041	
This Issue	: 2/23/2007 S.O. No. : N/A		Drawing Number	: D3213 REV A	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 30640		Material	: N/A	
Written By			Due Date	: 3/14/2007 Qty: 4 Um: Each	
Checked & Approved By					
Comment	: Est RevA		New Issue	05-11-17 17:27	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31613	Hinge 15.0"
		 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 2 D3161-3 Hinge <i>B23189 X# + 2</i> <i>B28287 X#</i> <i>PTO</i>
2.0	D32131	Door Panel
		 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D3213-1 Door <i>B 30656</i>
3.0	D32133	Door Panel
		 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D3213-3 Door <i>B 30657</i>
4.0	MS20470AD44	Rivet, Universal Head
		 
		Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 24 MS20470AD4-4 Rivet <i>M102328</i>

ml07/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	1	Scrap 2 DZ3161-3 (15° hinge) "Bad Tooling" <i>ml</i>	<i>ml</i>	Destroy & replace. Use new drill jig.	<i>ml</i> 07/03/13	<i>ml</i> 07/03/14	<i>ml</i> 07/04/12	<i>ml</i> 07/03/14

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOOR ASSEMBLY
Job Number: 30901		Part Number: D3213041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Assemble as per Dwg D3213 Identify as D3213-041		
		mlo7/03/13 x4
6.0	QC5	INSPECT WORK TO CURRENT STEP
		J0703-14(4)
Comment: INSPECT WORK TO CURRENT STEP		
7.0	POWDER COATING	POWDER COATING
		M18316
		m100700
		m-l
		07/03/30(1X)
Comment: POWDER COATING		
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Fel/m-l 07/03/14 (1)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	D2137	Decal - No Step
		mf. 07-03-19 (4)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
1 D2137 Decal V541368-		
10.0	D2419	Handle
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
1 D2419 Handle B29745-		
11.0	D2462	Neoprene Seal
Comment: Qty.: 2.4000 f(s)/Unit Total : 9.6000 f(s)		
Pick: Assembly Kit		
Qty Part Number Description Batch		
2 D2462 Seal B30878 -		
		mf. 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-04-09.	15;	Had to replace rivet + washer. Made hole bigger (Had to remove old rivet and it made the hole larger) ADM520470AD56 m9619 AN960308 m103492	MF	07-02-04	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30901

Part Number: D3213041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D27281 Dart Logo label small



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 D2728-1 Decal B24215

13.0 AN960JD6 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 AN960JD6 Washer M 40085

14.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 MS20470AD4-6 Rivet M 40085 M 103641 -

MF 07-03-19

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

MF 07-04-02 (4)

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAN 04 02

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/4/03 (4)

18.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/04/04 (4)

Job Completion



18.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

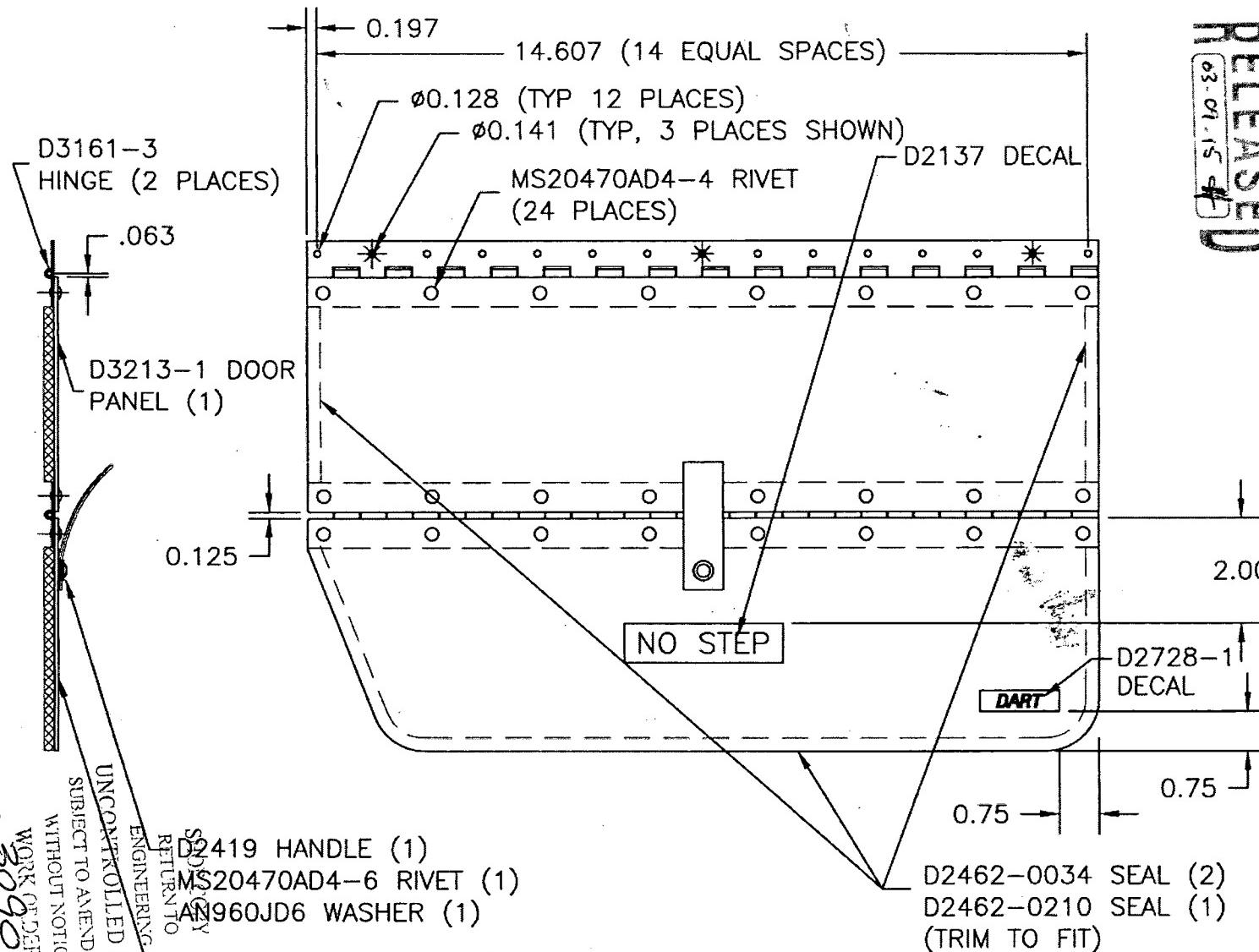
Copyright © 2003 by DART AEROSPACE LTD
AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT

۷۱۴

~~UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE~~

D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASER
03-01-15 #

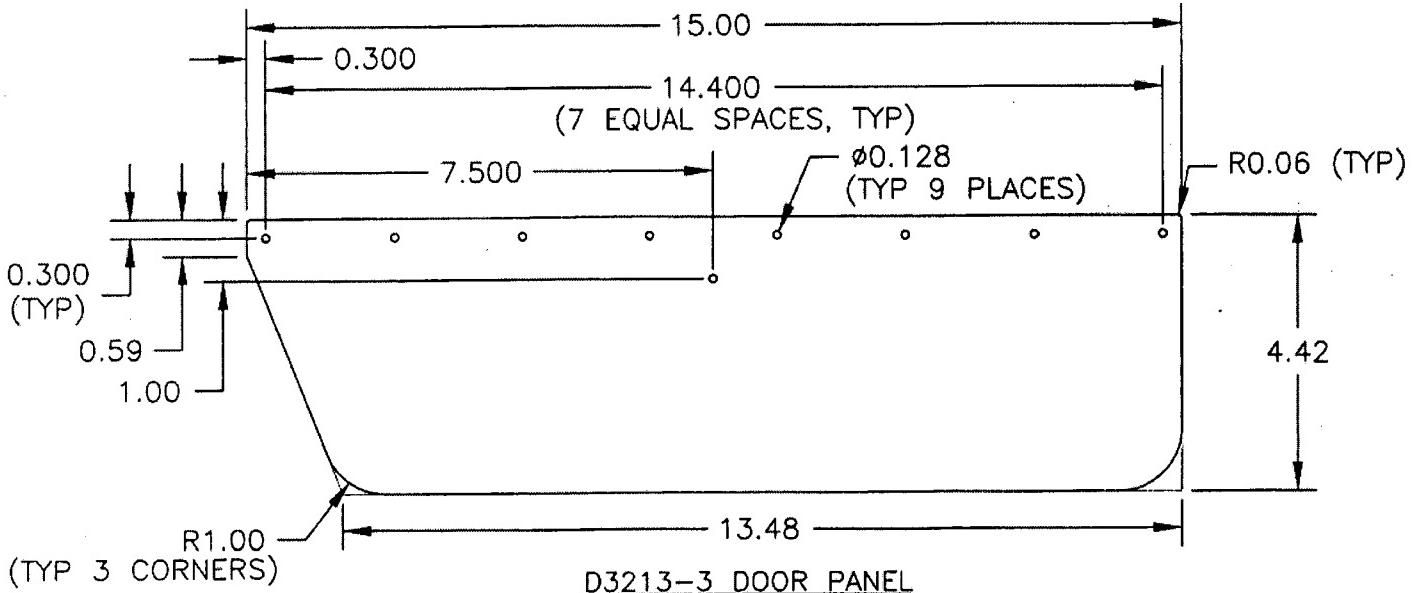
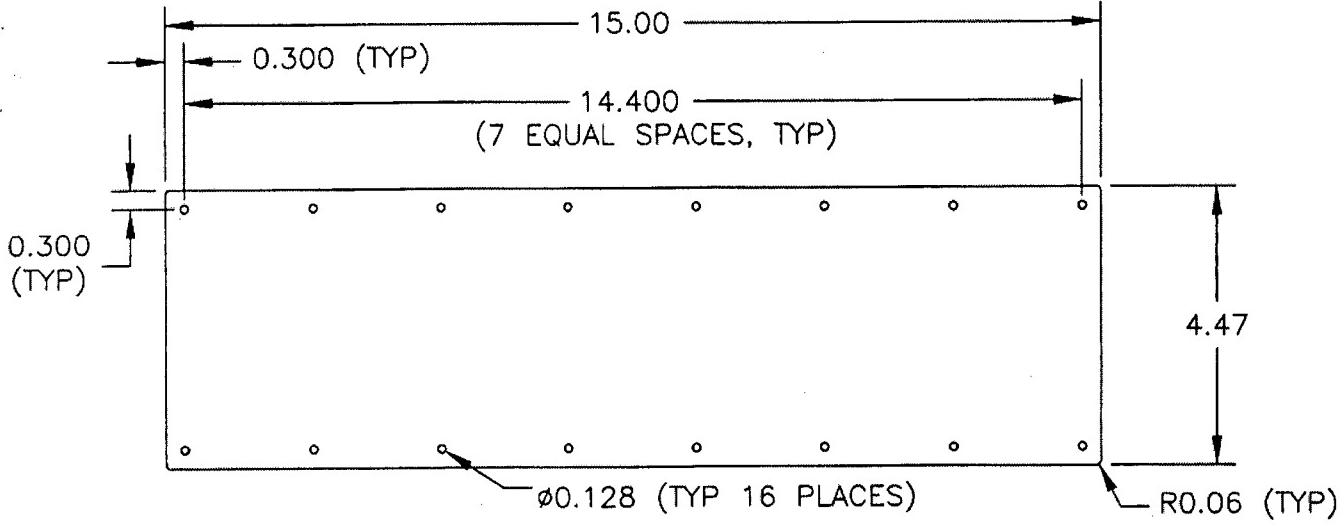
DART

		DRAWN BY	
		DESIGN	
<i>CP</i>		<i>CP</i>	
		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>H</i>	DRAWING NO.	
		D3213	
APPROVED	<i>H</i>	REV. A	
		1 OF 2	
DATE	03.09.03	SCALE	
		1:3	
TITLE	DOOR ASSEMBLY		NEW ISSUE
A	03.09.03		



© DART AEROSPACE LTD

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3213	2 OF 2
DATE	TITLE	SCALE	
03.09.03	DOOR ASSEMBLY	1:3	



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03
C
SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

Copyright © 2003 by DART AEROSPACE LTD

NO. 30701

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.